

SELECTION & SPECIFICATION DATA

Generic Type	Polyamine-Epoxy
Description	A solvent-less, high gloss, smooth epoxy coating for the lining of gas transmission pipelines. It's hard, smooth surface aids in the flow of gas by reducing turbulence while protecting the interior surfaces from corrosion. It has excellent flow and wetting characteristics ideal for this type of application and use. Tested in accordance with API RP 5L2 for gas transmission pipelines.
Features	<ul style="list-style-type: none"> • Improves flow efficiency in gas pipes • Meets API RP5L2 requirements for gas transmission pipeline flow liner • Excellent flow and leveling • Single-coat application • Hard, smooth, glossy finish • Excellent abrasion resistance • Corrosion prevention during storage
Color	Red 0500
Gloss	70+ @ 60°
Finish	Gloss
Primer	Self-priming
Dry Film Thickness	51 - 152 microns (2 - 6 mils) per coat Higher mils are used when increased corrosion prevention is needed.
Physical Properties	Specific gravity of 1.50
Solids Content	By Volume 100%
Theoretical Coverage Rate	39.4 m ² /l at 25 microns (1604 ft ² /gal at 1.0 mils) 19.7 m ² /l at 50 microns (802 ft ² /gal at 2.0 mils) 6.6 m ² /l at 150 microns (267 ft ² /gal at 6.0 mils) Allow for loss in mixing and application.
VOC Values	As Supplied : 1 g/l (0.008)lbs./gal)
Dry Temp. Resistance	Continuous: 120°C (248°F)

SUBSTRATES & SURFACE PREPARATION

General	Surfaces must be clean and dry before abrasive blasting. Employ adequate methods to remove dirt, dust, oil and all other contaminants that could interfere with adhesion of the coating.
Steel	SSPC-SP6, NACE 3, Sa 2 Surface Profile: 1.2-2.5 mils (30-63 microns)

PERFORMANCE DATA

All test data was generated under laboratory conditions. Field testing results may vary.

Test Method	System	Results
API 5L2	One coat Polyclad 956	Pass

Polyclad 956

PRODUCT DATA SHEET



MIXING & THINNING

Mixing | Polyclad 956 is a two component product. Part A and B needs to be power mixed before use.

Thinning | Thinning is not recommended

Ratio | Mix ratio is 2:1 by volume

Pot Life | 27 minutes at 75°F (24°C)
6 minute at 130°F (54°C)

APPLICATION EQUIPMENT GUIDELINES

Listed below are general equipment guidelines for the application of this product. Job site conditions may require modifications to these guidelines to achieve the desired results.

Conventional Spray | Not recommended to be applied by conventional spray.

Airless Spray | Pump Ratio: 30:1 (min.)
Material Hose: 3/8" I.D. (min.)
Tip Size: .013"-.021"
Output PSI: 1800-2500
Filter Size: 60 mesh
PTFE packings are recommended and available from the pump manufacturer

Plural Component Airless Spray | Recommended for application by plural component airless spray. Use fixed ratio, 2:1 heated airless pump. Spray with part A and B at 130°F (54°C).

Brush | Recommended for small areas and repairs only. Use a high quality medium bristle brush, and apply a very light crisscross brush coat. Allow to dry for approximately 5 minutes. Normally, a film thickness of 1-2 mils (25-50 microns) can be obtained per coat by this method.

APPLICATION CONDITIONS

Condition	Material	Surface	Ambient	Humidity
Minimum	49°C (120°F)	10°C (50°F)	10°C (50°F)	0%
Maximum	60°C (140°F)	43°C (110°F)	49°C (120°F)	90%

This product simply requires the substrate temperature to be above the dew point. Condensation due to substrate temperatures below the dew point can cause flash rusting on prepared steel and interfere with proper adhesion to the substrate.

CURING PROGRAM

Surface Temp.	Dry to Handle	Dry to Touch
10°C (50°F)	8.5 Hours	2 Hours
24°C (75°F)	3 Hours	1.25 Hours

CLEANUP & SAFETY

Cleanup | Use Thinner #2 or Acetone. In case of spillage, absorb and dispose of in accordance with local applicable regulations.

Safety | Read and follow all caution statements on this product data sheet and on the MSDS for this product. Employ normal workmanlike safety precautions.

PACKAGING, HANDLING & STORAGE

Shelf Life	Part A & B: Min. 12 months at 75°F (24°C) When kept at recommended storage conditions and in original unopened containers.
Shipping Weight (Approximate)	15 Gallon Kit - 190 lbs (86 kg) 150 Gallon Kit - 1905 lbs. (864 kg)
Storage Temperature & Humidity	40° - 110°F (4°- 43°C) 0-100% Relative Humidity
Flash Point (Setaflash)	Part A: >200°F (93°C) Part B: >200°F (93°C)
Storage	Store Indoors.

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